

Work Order ID 52917

October 19, 2009 12:59:04 PM

Page 1

Item ID: D2654-7

Revision ID: E1

Item Name: Web

Start Date: 10/19/09

Start Qty: 6.00

Required Date: 11/02/09

Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: *PK*

Date: *09-10-19*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2654

Rev E1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654 112-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654 113-Using the uni-bit, open holes to finish size as per Dwg D2654 114-Deburr holes and ends

BE/W 9/11/13

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DP 9-11-3

(8)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8 W 9/11/13

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Page 2

Item ID: D2654-7

Accept

Revision ID: E1

Item Name: Web

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 6.00

Required Date: 11/02/09 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

DP 9-11-3

8

140

Identify as per dwg & Stock Location: L.G.

0.00

Packaging

Memo

0.00

Packaging

DP 9-11-3

8

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/03
R 09-11-3
8

Picklist Print

October 19, 2009 12:59:08 PM

Page 1

Work Order ID: 52917

Parent Item: D2654-7RevE1

Parent Item Name: Web

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2600-7-140RevD1 | | Manufactured | No | | | 100 | Each | 72.0000 | 6.0000 | | | |



EXT. "I BEAM" THICK

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

41591

72

8 BB 09/11/03

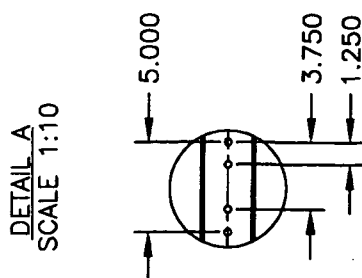
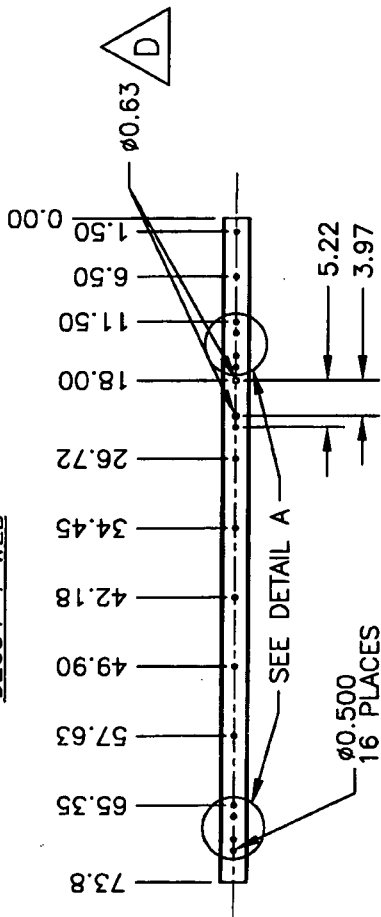
DART
DEO ATTACHED



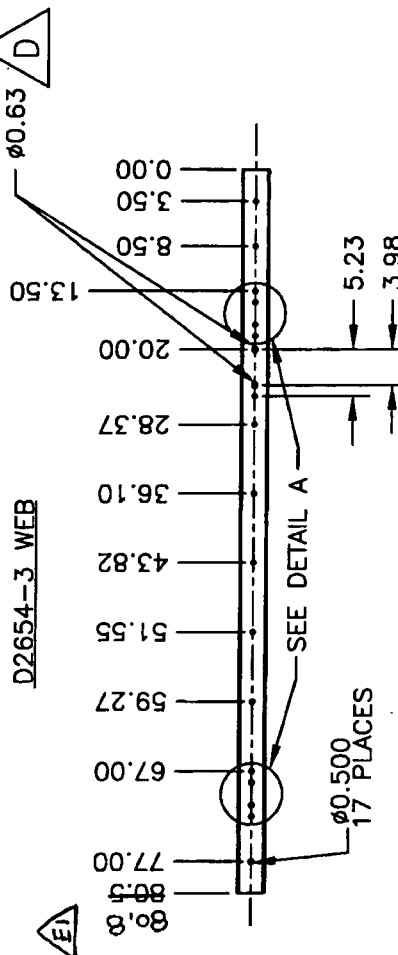
| | | | |
|---------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D2654 | REV. E SHEET 1 OF 2 |
| DATE 04.05.26 | | TITLE WEB | SCALE 1:20 |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.06.26 | ALTER HOLE PATRN., 0.500 WAS 0.438 | |
| C | 97.10.29 | CHANGED HOLE PATTERN | |
| D | 98.01.15 | GHW HOLES CHANGED TO $\phi 0.63$ | |
| E | 04.05.26 | CHANGE LENGTHS, REFORMAT | |
| E1 | <i>CP</i> 04.08.04 | PER TOOLING; 80.8 WAS 80.5 | |

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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WORK (

NO. 5-2917

PM 09-10-19

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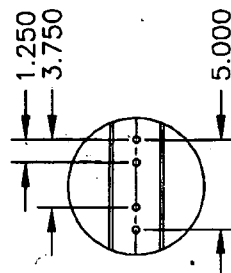


| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN UP | DRAWN BY UP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2654 | REV. E SHEET 2 OF 2 |
| DATE 04.05.26 | | TITLE WEB | SCALE 1:20 |

RELEASED
04.06.22

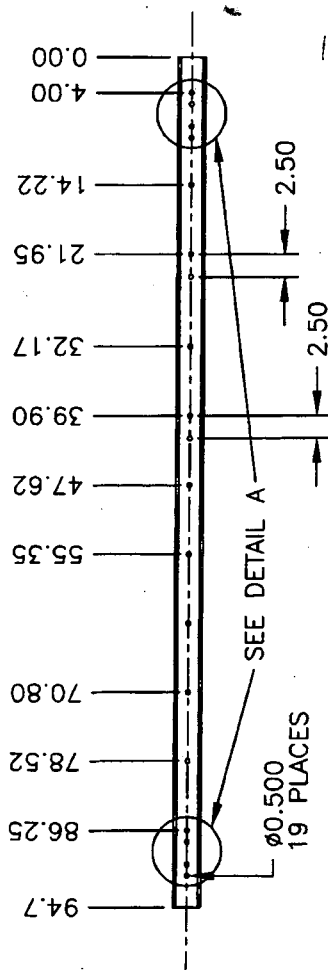
DEO ATTACHED

DETAIL A
SCALE 1:10

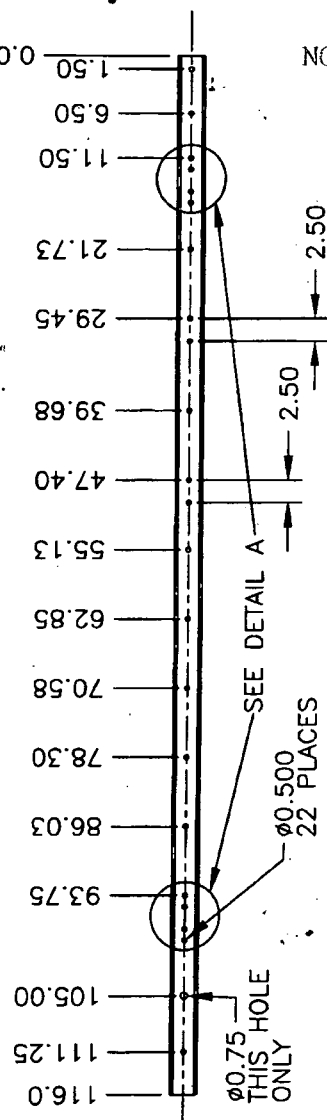


SHOP
REVIEW
ENGINEER
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SUBJECT TO
WITH
WORK
NO. 52917

D2654-5 WEB



D2654-7 WEB



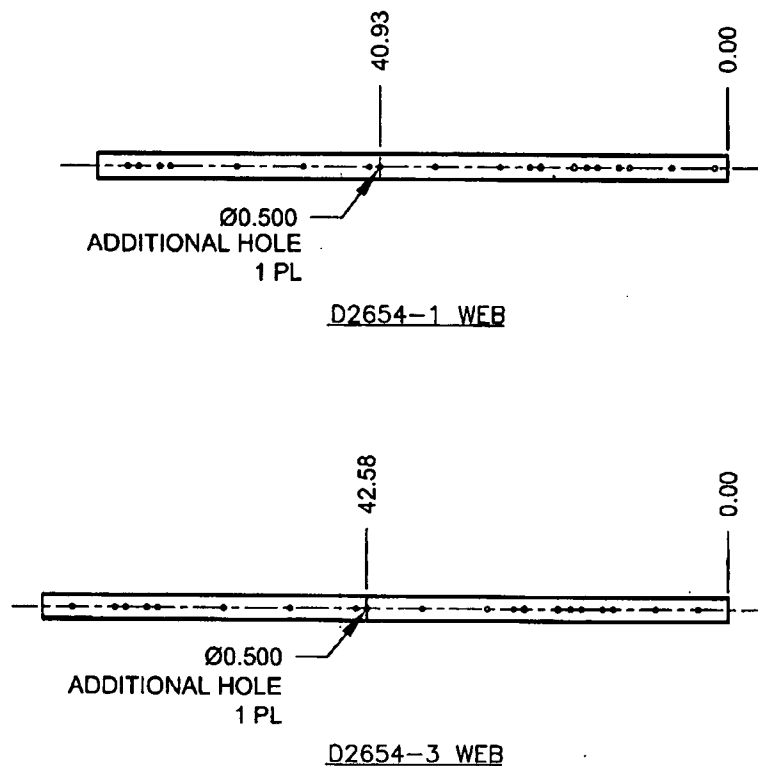
MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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| | | | | | | | |
|----------------------|----------------------|------------------------|--|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D2654 | TITLE WEB | REV. E1 | DART AEROSPACE USA, INC ENGINEERING ORDER | | D.E.O. NO. D2654-E-2 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>CP</i> | CHECKED <i>PH</i> | MFG. APPR. <i>E</i> | APPROVED <i>MP</i> | | DE APPR. <i>MP</i> | | |
| DATE 09.03.11 | DATE 09.03.11 | DATE 09.04.03 | DATE 09.04.03 | | DATE 09.04.03 | | |

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:



RELEASED
09/04/08 MP

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WORK ORDER
NO. *52917*

THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.